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- 62. The method of claim 22 further comprising providing V_t shift inducing material over the insulation layer.
- 63. The method of claim 29 wherein the barrier layer is formed on the first insulation layer.

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- 64. The method of claim 36 wherein the barrier layer is formed on the insulation layer.
- 65. The method of claim 43 wherein the barrier layer is formed on the insulation layer.